

Work Order ID 114462

March-05-14 2:48:55 PM

114462

Page 1

Item ID: D3319-3
 Revision ID: B114462
 Item Name: Full-Length Wearplate
 Start Date: 3/05/14 Start Qty: 12.00
 Required Date: 3/14/14 Req'd Qty: 12.00
 Reference:

Accept *N900040100* Setup Start *NS1*
 Stop *NS2*
 Cust Item ID:
 Customer:

Approvals: Process Plan: MLS Date: 14-03-05
 QC: Date:

Tooling: Date:
 SPC (Y/N): Date:

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								

100
 100
 Waterjet
 FLOW CNC Waterjet
 1010 . 050"
 FLOW WATER JET
 Memo
 1-Cut as per Dwg D3319
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

0.00
 0.00
 12 0 Jm14-03-7

110
 110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo

0.00
 0.00
 12 0 Jm14-03-7

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Page 2

Item ID: D3319-3

Revision ID:

Item Name: Full-Length Wearplate

Start Date: 3/05/14

Start Qty: 12.00

12

Required Date: 3/14/14

Req'd Qty: 12.00

12

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

Quality Control

0.00

0.00

140

NC BRAKE

140

Brake NC

Memo

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: C

0.00

DAS
30
9-89

150

QC6- Inspect dimensions to drawing

0.00

150

QC

Memo

Quality Control

0.00

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Page 3

Item ID: D3319-3

Revision ID:

Item Name: Full-Length Wearplate

Start Date: 3/05/14

Start Qty: 12.00

12

Required Date: 3/14/14

Req'd Qty: 12.00

12

Reference:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

Large Fab

Large Fab

Weld per dwg A/R Hardcoat steel Batch: m124434 → 228
Large Fab

Memo

0.00

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319
Batch A/R 7560 Hardcoat Rod m124434 → 228

0.00

0.00

0.00

0.00

(12)

372

14-03-18

(12)

14-03-18

DAS
9
9-89

(12)

14-03-18

DAS
9
9-89

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

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Page 4

Item ID: D3319-3
Revision ID:
Item Name: Full-Length Wearplate
Start Date: 3/05/14 Start Qty: 12.00 *12*
Required Date: 3/14/14 Req'd Qty: 12.00 *12*
Reference:

Accept *N900040100* Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 125028 Memo START TIME: 8:40. OVEN TEMPERATURE: 320° FINISH TIME: 9:10.	0.00 0.00				12	0	4-3-19	DAS 34 9-89
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12			DAS 27 9-89 4/3/19
210 *210* Packaging Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following:TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-3, B/N: BXXXXXFor Product Eligibility see PDA05-18 and Stock Location: SLS00	0.00 0.00							DAS 06 9-89 12 MAR 27 2014

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Page 5

Item ID: D3319-3**Revision ID:****Item Name:** Full-Length Wearplate**Start Date:** 3/05/14 **Start Qty:** 12.00**Required Date:** 3/14/14 **Req'd Qty:** 12.00**Reference:****Approvals:** **Process Plan:** _____ **Date:** _____**QC:** _____ **Date:** _____**Accept*****N900040100*****Setup Start *NS1*****Stop *NS2*****Cust Item ID:****Customer:****Run Start *NR1*****Stop *NR2*****Sequence ID/
Work Center ID**

220

220

QC

Quality Control

**Operation
Description**

QC21- Final Inspection - Work Order Release

Memo**Set Up/
Run Hours**

0.00

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

MLJ 14-03-21
MLJ 14-03-20

Picklist Print

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Page 1

Work Order ID: 114462

114462

Parent Item: D3319-3

D3319-3

Parent Item Name: Full-Length Wearplate

Start Date: 3/05/14

Required Date: 3/14/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: A05.05.12New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S18GA

Purchased

No

100

sf

105.6709

3.2524

42

M1010S18GA

Jm14-03-7.

1010/1025 SHEET .048

Location

Loc Qty

Loc Code

MAT019

105.6709

116268

0.970948

117806

18

124428

31

m127805

55.7

127805

DART AEROSPACE LTD		Work Order:	114462
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.190	+0.005/-0.001	0.192"	—		V	Jkmo1
Ø0.500	+0.006/-0.001	0.501"	—		V	
0.316	+/-0.010	0.317"	—		V	
0.607	+/-0.010	0.611"	—		V	
2.94	+/-0.030	2.952"	—		V	
2.69	+/-0.030	2.702"	—		V	
3.527	+/-0.010	3.534"	—		V	
4.52	+/-0.030	4.530"	—		V	
5.063	+/-0.010	5.063"	—		V	
6.16	+/-0.030	6.169"	—		V	
0.60	+/-0.030	0.608"	—		V	
8.690	+/-0.010	8.695"	—		V	Jkmo8
30.790	+/-0.010	30.790"	—		T	Jkmo7
52.88	+/-0.030	52.88"	—		T	
62.770	+/-0.010	62.770"	—		T	
74.420	+/-0.010	74.420"	—		T	
75.52	+/-0.030	75.52"	—		T	
0.050	+/-0.010	0.049"	—		V	

DAS

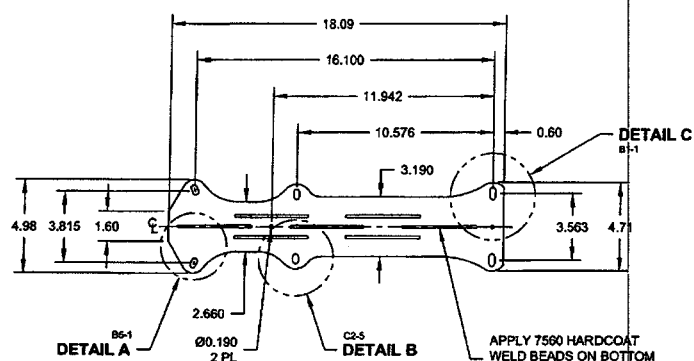
27

Measured by: JM	Audited by: 9-89	Preliminary Approval:
Date: 14-03-7	Date: 14/3/10	Date:

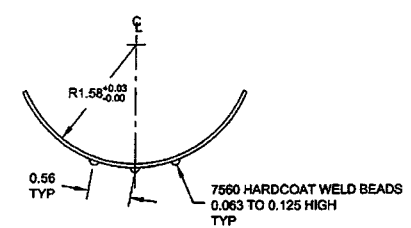
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	

654

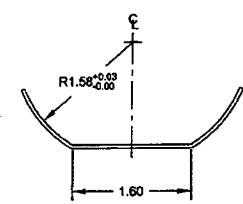
114462 MJS
14-03-05



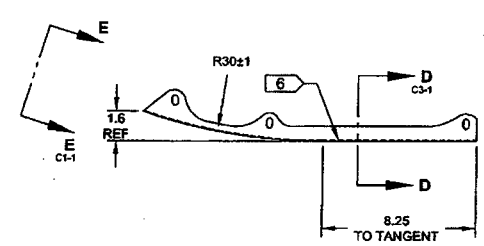
D3319-1F FLAT PATTERN



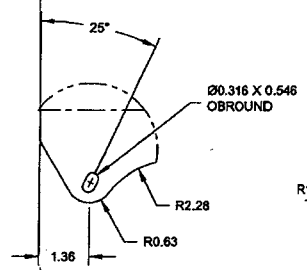
SECTION D-D
SCALE 4X



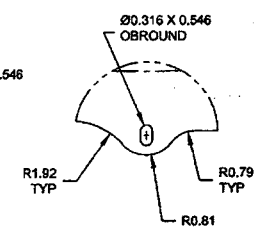
SECTION E-E
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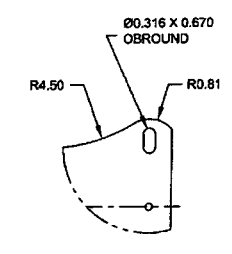
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

D3319-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

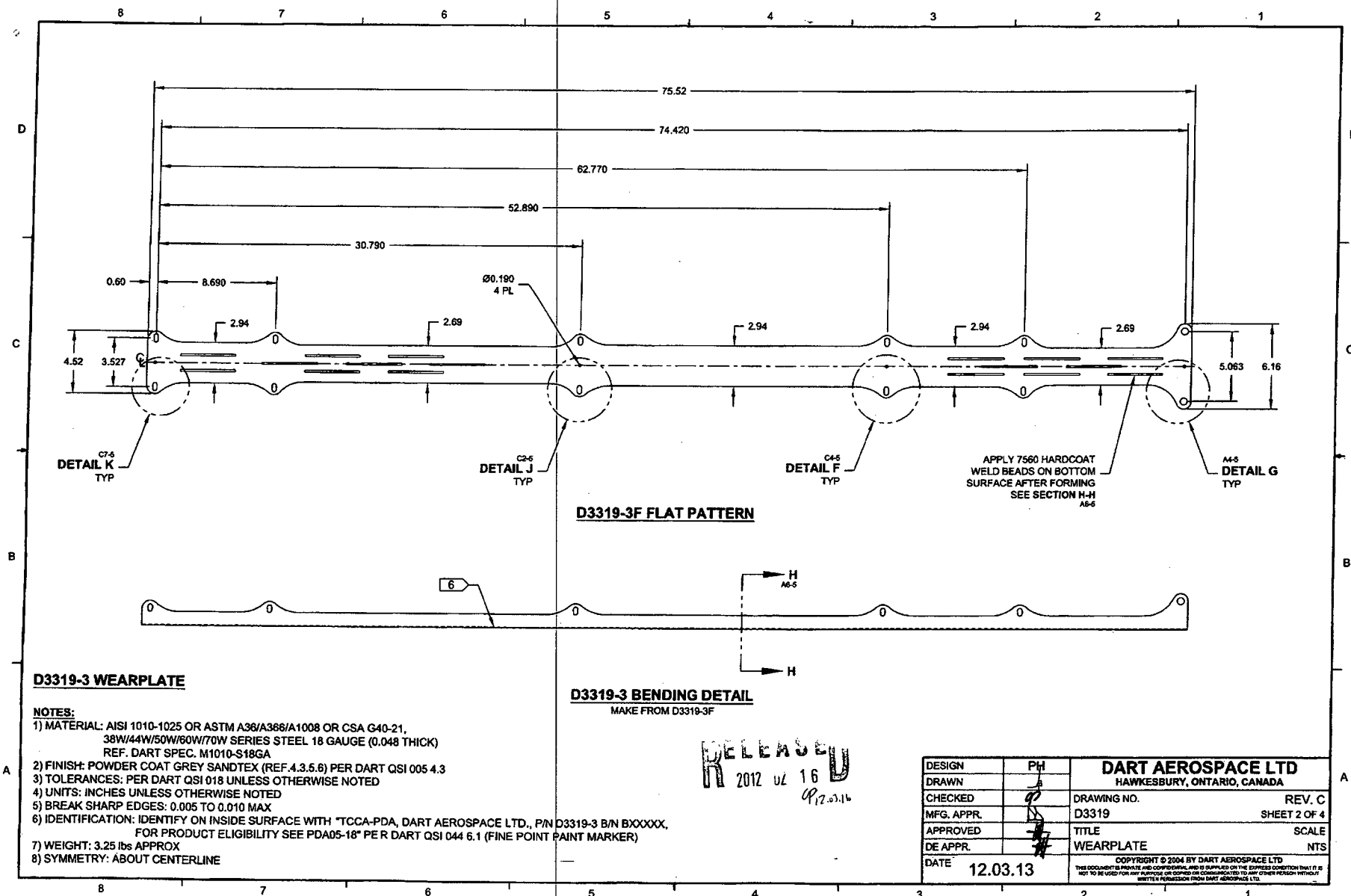
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2012-03-16
PER ECN 12-546 12.03.16

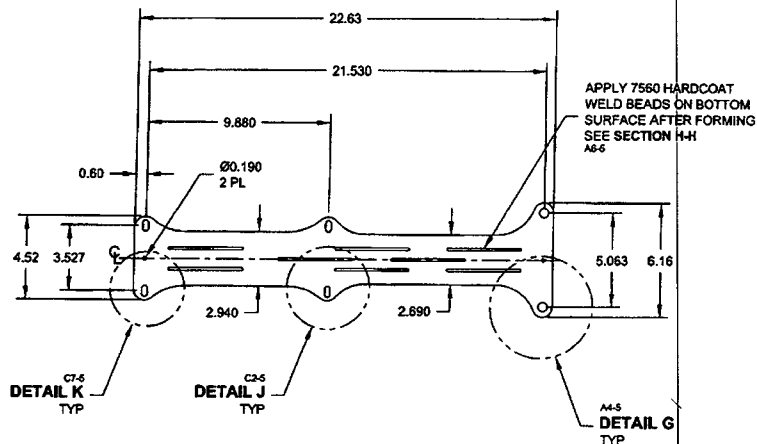
C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/-5/-7 (REF DETAIL G); SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/-5/-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

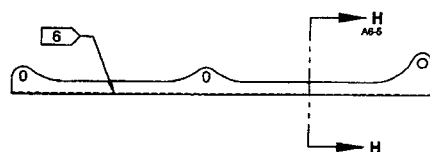
DRAWING NO. D3319
TITLE WEARPLATE
REV. C
SHEET 1 OF 4
SCALE NTS

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D3319-5F FLAT PATTERN



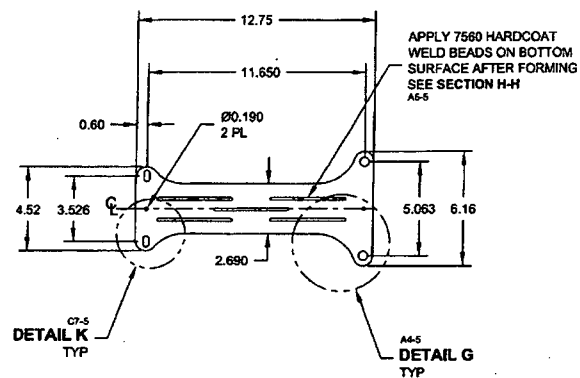
D3319-5 BENDING DETAIL

MAKE FROM D3319-5F

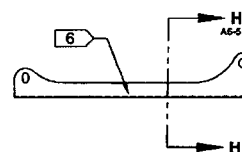
D3319-5/-7 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE



D3319-7F FLAT PATTERN

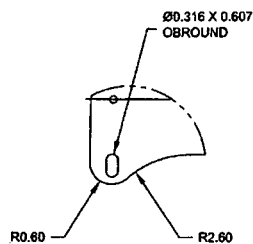


D3319-7 BENDING DETAIL

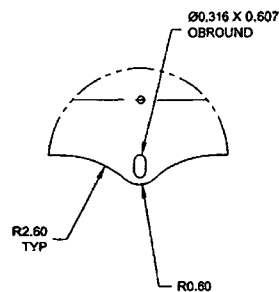
MAKE FROM D3319-7F

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2012-02-16
P2.0316

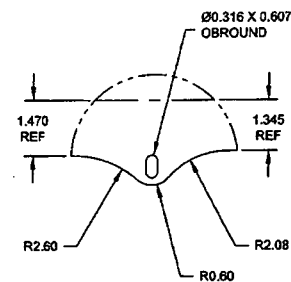
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P	DRAWING NO.	REV. C
MFG. APPR.	J	D3319	SHEET 3 OF 4
APPROVED	J	TITLE	SCALE
DE APPR.	J	WEARPLATE	NTS
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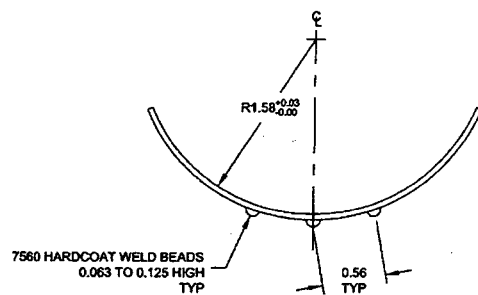
DETAIL K B8-2
C4-3
C6-3
SCALE 2X



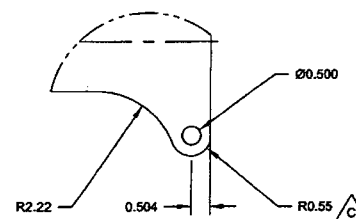
DETAIL F B3-2
SCALE 2X



DETAIL J B8-2
C7-3
SCALE 2X



SECTION H-H B4-2
B3-3
B6-3
SCALE 4X



DETAIL G B8-2
C2-3
C6-3
SCALE 2X

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2012-02-16
4/12.03.16

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CHECKED	Q	DRAWING NO.	REV. C
MFG. APPR.	S	D3319	SHEET 4 OF 4
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